

Work Order ID 75579

October-25-11 3:12:23 PM

75579

NO. 812

Page 1

Item ID: D3325-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 25/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.C.S Date: 11/10/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3325	Rev B

100 0.00
100 Large Fab
 Large Fab
 Large Fab

Memo 0.00
 1-Cut tubes as per Dwg D3325

PC 11.11.03

Qty	Part Number	Description	Batch
2	D3325-1	End Tube	<u>4109127</u>
3	D3325-3	Interior Tube	<u>4109127</u>
2	D3325-5	Full Length Tube	<u>M119441</u>

- Identify parts appropriately
- 2-Remove all markings from material
- 3-Drill and Weld as per Dwg D3325 & QSI 004
A/R4130Steel Rod 118875
- 4-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	BE 11/14/03	
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				11	11	03 ①	
121 *121* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							NO M-11/14/03

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME: 1:15

OVEN TEMPERATURE: 400 OF

FINISH TIME: 1:45

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

Handwritten: NX MP 11/11/03

Handwritten: 1 BR 11-11-03

Handwritten: M118439

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: S-A	0.00							
150									
Packaging	Memo 755 69 w/o	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

[Handwritten signature] 11/11/07 ①

[Handwritten signature] 11/11/07

[Handwritten signature] 11-11-07 ①

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Picklist Print

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Page 1

Work Order ID: 75579

75579

Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3328-1 *D3328-1* Basket Hinge		Manufactured	No			100	Each	23.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		23								
			33871		23								
✓ D3349-1 *D3349-1* Spacer Bushing		Manufactured	No			100	Each	28.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		28								
			44401		28								
✓ D3352-1 *D3352-1* Label Plate		Manufactured	No			100	Each	14.0000	1	1	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		14								
			41925		14								
✓ D3367-1 *D3367-1* Mounting Bracket		Manufactured	No			100	Each	20.0000	2	2	**	11/10/26	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA005		20								
			43228		20								

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 75579

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Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

270.9988

20.5416

21.62274

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

B119441 14.41

11/10/2011

Location

Loc Qty

Loc Code

MAT034

270.9988

109127

216

109385

15.75

112786

39.2488

7.21

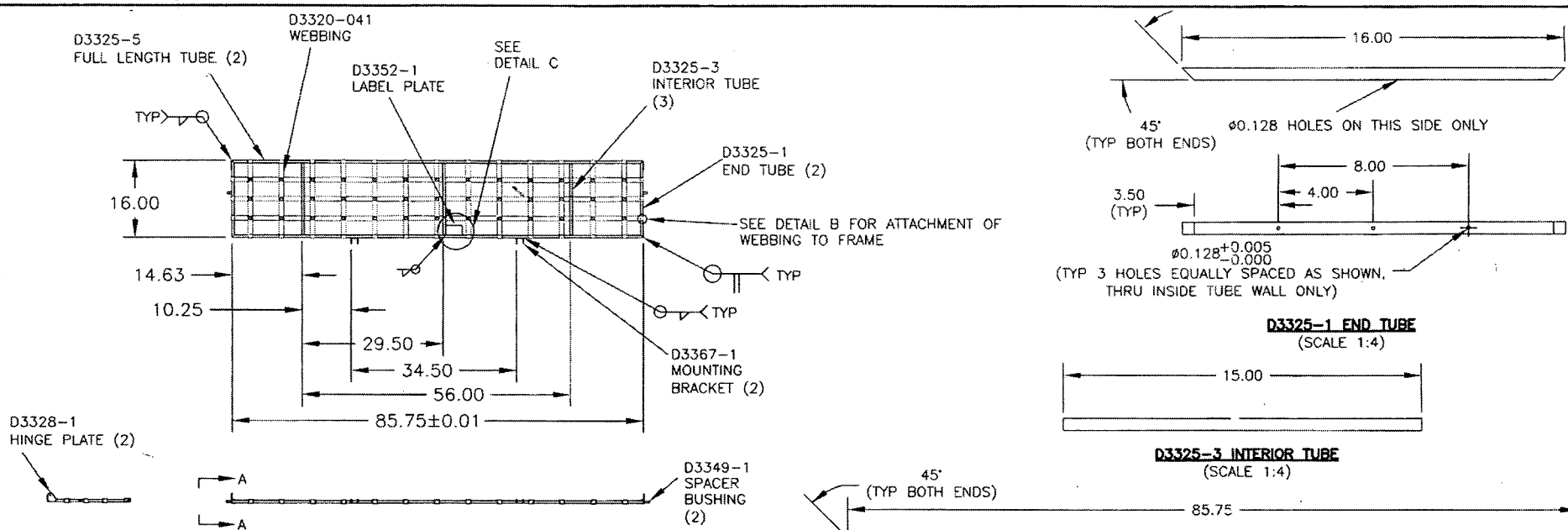
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN960J/D3	32	WASHER

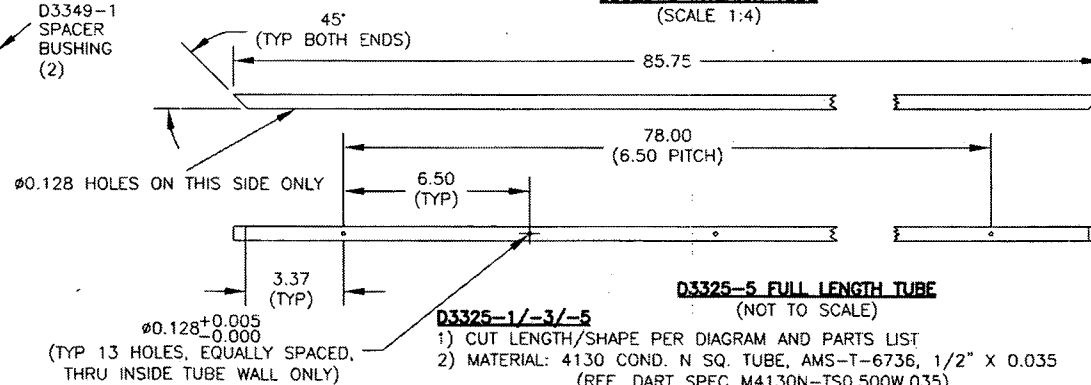
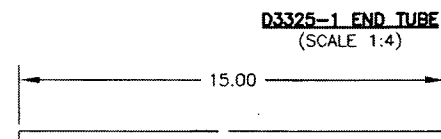
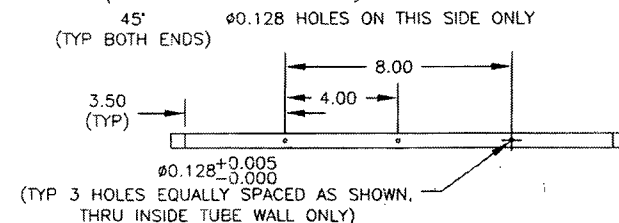
RELEASED
05-04-25

DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75579 H.C.J

11/10/25



D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DART
DATE	05.04.25	BASKET LID ASSEMBLY

REV. B
SHEET 1 OF 3
SCALE
1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

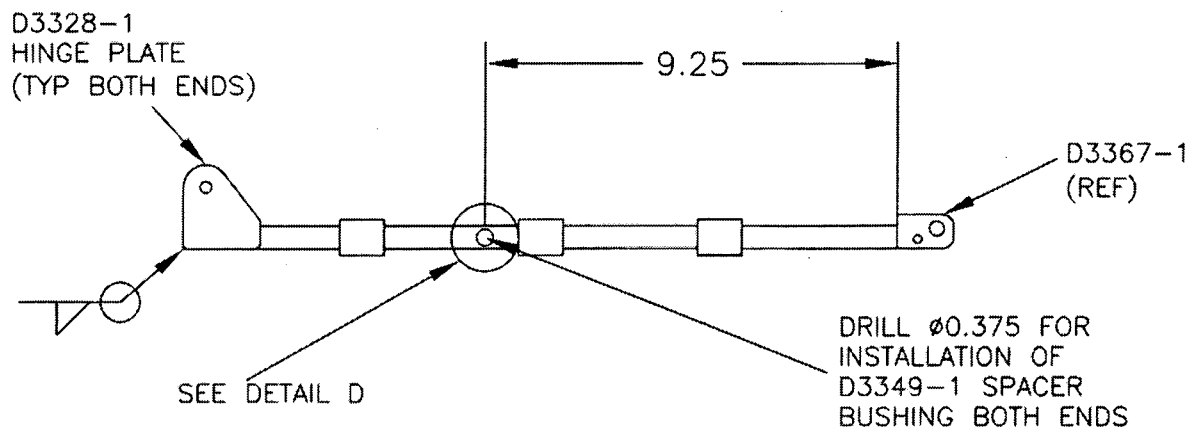
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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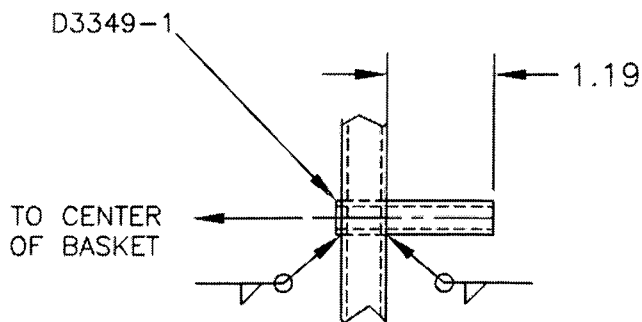
NOTE: Date & initial all entries



DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D
(SCALE 1:2)

DEO ATTACHED
RELEASED
05.04.28 [Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

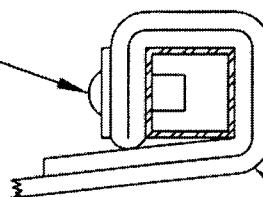
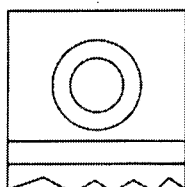
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DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. 8 SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

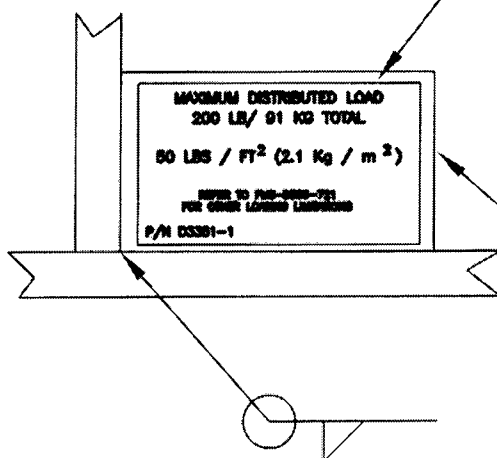


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28
DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET

WAS:

MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

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